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5150235

split
30

D5713-041
Job Sheet 187931



Part No: D5713-041

Job Qty: 330 pcs

Part Name: Receptacle Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5713 REV.A3 IPP REV:A 18.12.18 NEW ISSUE DD VERF:DP

Ship Via:

007195

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Small Fab - 1	330 pcs	1/4/19		0.00	20.63	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	DAS
							Small Fab - 4	36
							Small Fab - 5	9-89
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	330 pcs	1/4/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	DAS
							QC 5 - 3	30
							QC 5 - 38	9-89
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
120	Packaging 3-1 - Stock - B4B	330 pcs	1/4/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	

ST 18/19

MAR 26 2019

19/03/25

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

1
239
91
330

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

130 QC 21 - SA	330 pcs	1/4/19	0.00	0.00	QC 21 - SA - 21	DAB
					QC 21 - SA - 70	21

MAR 26 2019

Part Op
Descriptions: 100 - Install nutplate as per dwg.

9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5713-1	Receptacle Plate	330 pcs (1 ea)	100-Small Fab - 1	51408972 X 5142844X
MS20426AD3-4	Rivet	660 Ea (2 ea)	100-Small Fab - 1	45136444-2-1
MS21047L4	Nut Plate	330 Ea (1 ea)	100-Small Fab - 1	5159784

91
100X
5163514 218X

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D5713-1	330	8	0
	MS20426AD3-4	660	3,945	0
	MS21047L4	330	3	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



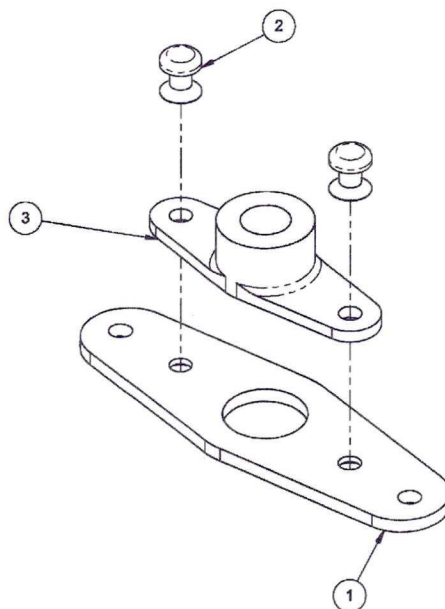
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM	QTY	P/N	DESCRIPTION
X	X	D5713-041	RECEPTACLE ASSY
1	1	D5713-1	RECEPTACLE PLATE
2	2	MS20426AD3-(4)	RIVET, SOLID, CSK
3	1	MS21047L4	NUTPLATE



D5713-041 RECEPTACLE ASSY

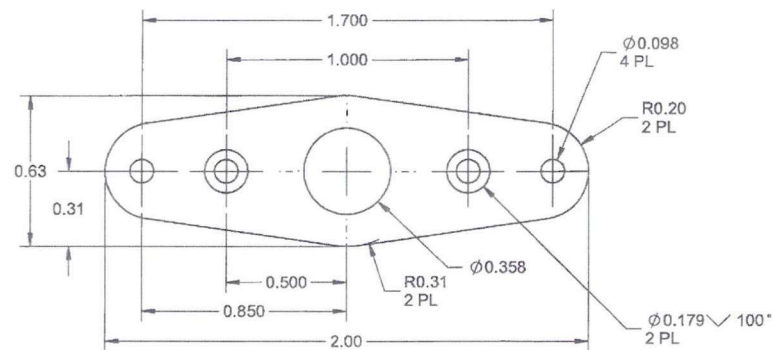
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.7
- 7) WEIGHT: 0.02 lbs

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WORK ORDER
NO. 187931 M.C.S.
1872-4

APPROVED

A	NEW ISSUE, REF CAR 18-282		VS	18.12.12
REV.	DESCRIPTION		BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	WK	DRAWING NO.	REV. A	
MFG. APPR.	DD	D5713	SHEET 1 OF 2	
APPROVED	VS	TITLE	SCALE	
DE APPR.	DS	RECEPTACLE	NTS	
DATE	18.12.12		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5713-1 RECEPTACLE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063" THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5713	SHEET 2 OF 2
APPROVED	VS	TITLE	SCALE
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DART SERVICE BULLETIN SB18-4

REF. TCCA STC: SH14-14
REF. FAA STC: SR03538NY
REF. ANAC STC: 2014S07-11
REF. JCAB STC: STC-372-OSA/STC-371-OSA
REF. EASA STC: 10056574

It has come to Dart's attention that a QD3072-46 Receptacle on the QB21308 Assembly Screen manufactured by Pall Aerospace as part of the D350-822-011/-013 PA100 PUREair System may have come loose in service, may have been ingested during aircraft ground runs and may have caused FOD damage to the engine on that aircraft.

Following this recent incident, Dart recommends that operators with the D350-822-011/-013 PA100 PUREair System installed on their aircraft take the following action PRIOR TO THEIR NEXT FLIGHT.

1. Remove the Upper Engine Cowl per the Aircraft Maintenance Manual.
2. Remove the Air Intake Seal and the entire QB21308 Assembly Screen by removing qty(22) fasteners washers per the Aircraft Maintenance Manual. Retain hardware.
3. Inspect the 1/4 turn fasteners for wear and/or bending damage from the Transition Duct, particularly if the D350-822-011/-013 kit has been installed on an aircraft with dual hydraulics and the D5090-041 Duct Assy has been installed. Inspect the D5090-041 Duct Assy for evidence of impingement and correct alignment with the seal and FOD screen. If wear and/or bending damage and/or misalignment is observed, contact Dart Customer Support immediately for disposition.
4. Separate the FOD screen from the QB21496 Receptacle by turning the 1/4 turn fasteners and lifting the handle per Figure 1.
5. Inspect the QD3072-46 Receptacles on the backside of the QB21496 Receptacle by applying 10-20 lb (5-10 kg) of finger pressure to ensure that they are not coming loose. A gap between the receptacle barrel and rivet plate is an indication of a loose/damaged receptacle.
6. If any of the QD3072-46 Receptacles are determined to be loose or spinning, contact Dart Customer Support immediately for disposition.
7. If the QD3072-46 Receptacles are determined to be well installed, re-install the FOD screen onto the QB21496 Receptacle. Verify that the 1/4 turn fasteners are fully engaged into the corresponding QD3072-46 Receptacles.
8. Customers who are concerned about the integrity of the QD3072-46 Receptacles may choose to replace them with bolts and non-floating anchor nuts using the DSI 9815-011 kit, which may be procured from Dart.
9. Ensure the Engine Intake is clear.
10. Reinstall the QB21308 Assembly Screen between the Engine Intake Duct and the Air Intake Seal removed at step 2 using qty(22) fasteners per the Aircraft Maintenance Manual.
11. Reinstall the Upper Engine Cowl per the Aircraft Maintenance Manual.

WARNING: It is imperative that each time the FOD Screen is removed from the intake per Section 71.5 of ICA-D350-822 to perform inspections that the qty(4) 1/4 turn fasteners are fully engaged into the corresponding Receptacles when the FOD Screen is re-installed per Section 71.6 of ICA-D350-822. Customers should try to limit the frequency with which the FOD Screen is taken in and out of the aircraft.

NOTE: The QB21308 Assembly Screen MUST be installed for flight.

APPROVED

A	NEW ISSUE	VS	18.12.03
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	SB18-4	SHEET 1 OF 2
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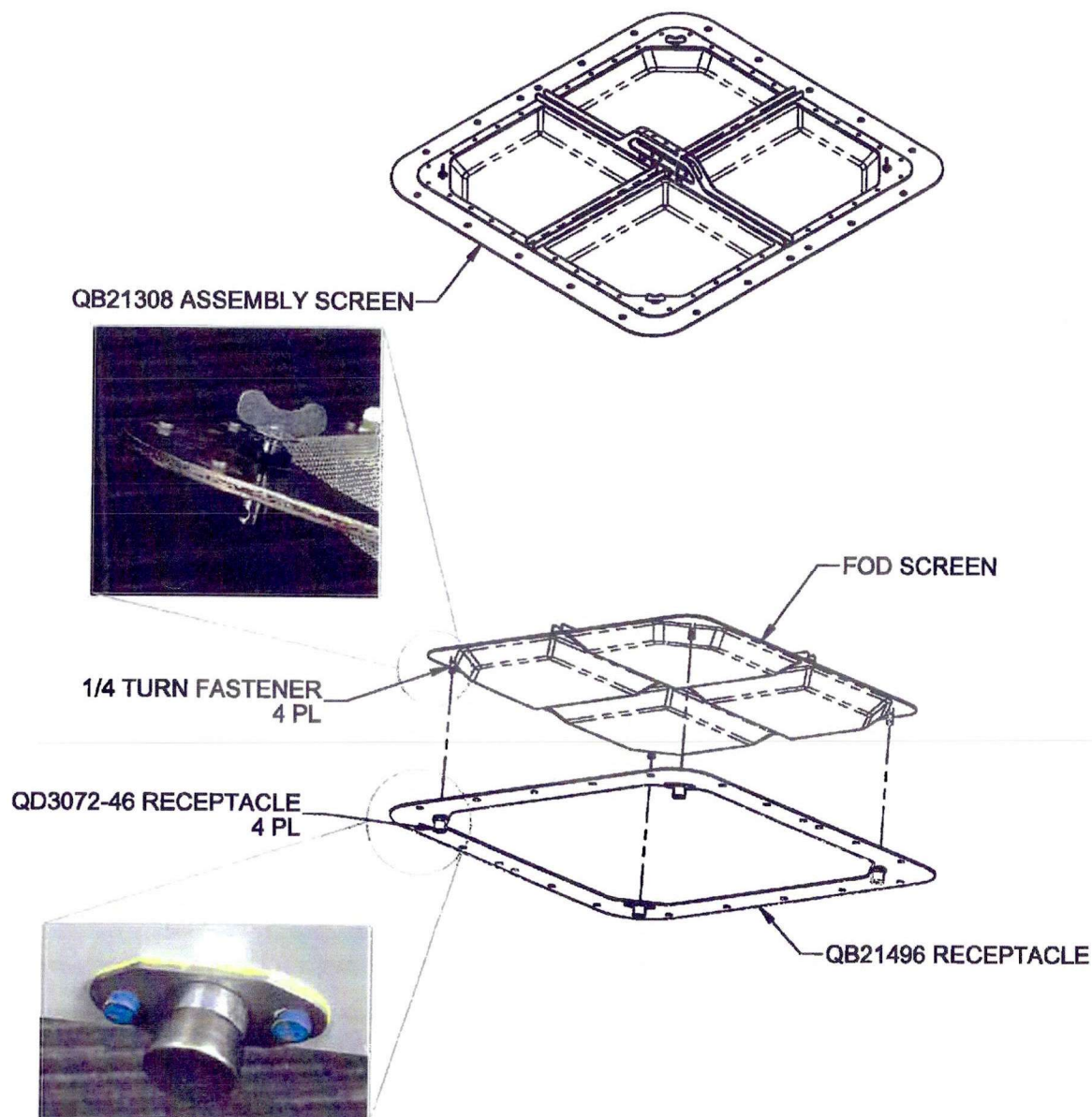


Figure 1 - QB21308 Assembly Screen

For further information, contact Dart at:

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email: support.on@dartaero.com
website: www.dartaerospace.com

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DESIGN	VS
DRAWN	VS
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MFG. APPR.	N/A
APPROVED	VS
DE APPR.	DS
DATE	18.12.03

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
SB18-4

TITLE
SERVICE BULLETIN

REV. A
SHEET 2 OF 2
SCALE
NTS

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